

64309 BLUE  
DeRev:  
Work Order ID 53595

November 9, 2009 1:33:50 PM

Page 1

Item ID: D206-642-441

Accept

Setup Start

Revision ID: F

Stop

Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *PR*

Date: *09-11-9*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

0.00

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

*N/A*

# Work Order ID 53595

November 9, 2009 1:33:50 PM



Page 2

Item ID: D206-642-441

Revision ID: F

Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00

Required Date: 20/11/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M112507/M111989 BE 09/11/10								
	4-Grind weld flush to cap on top surface only. BE 09/11/10								
	5-Cut aft end 138.60" from front of tube								
	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".								
	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".								
	8-Open using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650								
	11-Deburr and Blow out all chips form inside the tube								

11/11/9

11/11/10

**Work Order ID 53595**

November 9, 2009 1:33:50 PM



Page 3

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1

20.11.10

116



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

1

20.11.10

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

1

20.11.10

**Work Order ID 53595**

November 9, 2009 1:33:50 PM



Page 4

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9-11-10

**Work Order ID 53595**

November 9, 2009 1:33:50 PM



Page 5

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.  
cure time before cutting☐Start Date: 9/11/10 ☐

Time: 3:15

☐Finish Date: 9/11/11 ☐

Time: 11:30

A/R ☐ Sikaflex-291 ☐ M12219 ☐

Sikaflex expiry date: 10/2/30

1 29/11/10

**Work Order ID 53595**

November 9, 2009 1:33:50 PM



Page 6

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. A/R Aluminum Rod <u>M112507</u> <u>BE 09/11/11</u>								
	2-Grind welds flush as per Dwg D2650.								
	3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr								

10BE09/11/11111/11/12

**Work Order ID 53595**

November 9, 2009 1:33:50 PM



Page 7

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Skidtubes	HandFinishing	0.00				1			
Skidtubes	Memo Install D2680-041 Nut Plate as per Dwg D2650	0.00							
180  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
190  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

# Work Order ID 53595

November 9, 2009 1:33:50 PM



Page 8

Item ID: D206-642-441  
Revision ID: F  
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 09/11/2009 Start Qty: 1.00  
Required Date: 20/11/2009 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3  
Touch-up Alodine  
Memo

0.00

0.00

=> M 09/11/10

(21)

Ø

215



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

Memo

Prime Grey B 110918  
Spraypaint Delfleet Blue B 113171  
Clear Delfleet B 113088

0.00

0.00

M 09 11 25 (1)

225



QC

Quality Control

QC14- Inspect Spray Paint

Memo

0.00

0.00

Ø 09-11-26 (21)



**Work Order ID 53595**

November 9, 2009 1:33:50 PM

Page 9

Item ID: D206-642-441

Accept

Setup Start

Revision ID: F

Stop

Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ M11/2345  
Sikaflex expiry date: ☐ 10/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☒ M11/2345  
Sikaflex expiry date: ☐ 10/086-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 ☐Batch: M112023X1W.D. 09/11/20

**Work Order ID 53595**

November 9, 2009 1:33:50 PM



Page 10

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1 \_\_\_\_\_ *[Signature]* 09/11/07

250



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-642-441

Location: \_\_\_\_\_

PPP Rev: *PAAS3291*

\_\_\_\_\_ *[Signature]* 09/12/07

260



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

\_\_\_\_\_ *[Signature]* 09/12/07

*MF*  
09-12-07

# Picklist Print

November 9, 2009 1:34:06 PM

Page 1

Work Order ID: 53595

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Date: 09/11/2009

Required Date: 20/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2646RevC Manufactured No



Aft Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

36

20208

0

43801

1

46327

4

48109

31

110

Each

5.0000

1.0000

D2620RevB

Manufactured No



Skidtube, 206 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

45898

5

140

Each

15.0000

1.0000

D2647RevF

Manufactured No



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

15

10773

7

43846

8

XL MD 09/11/20

1 11/11/09

6 BE 09/11/10

# Picklist Print

Page 2

November 9, 2009 1:34:06 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2654-7RevE1		Manufactured	No			160	Each	3.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Web

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG *BS* 3

52801 2

52917 1

CCR264SS3-3		Purchased	No			170	Each	149.0000	2.0000			
-------------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



Cherry Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 149

111548 36

111827 1

112314 12

113064 100

*1* *09/11/10*

*2* *09/11/12*

November 9, 2009 1:34:06 PM

Shop Packet Print

Page 2

# Picklist Print

November 9, 2009 1:34:06 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			170	Each	243.0000	23.0000			
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

83

51529

83

Main Warehouse

ST

160

36013

5

47112

151

48271

4

*23 BE 09/11/11*

D2680-041RevB1

Manufactured

No

170

Each

68.0000

1.0000



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

68

33061

4

44086

64

*1 11/11/12*

# Picklist Print

Page 4

November 9, 2009 1:34:06 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS4-1032-130		Purchased	No			230	Each	4,919.000	60.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Insert

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

110511

4919

4919

230

Each

5,717.000 62.0000



x60 WMD 09/11/26

AN9601DTOL AN960C10L

Purchased

No



Washer

09/11/12

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

101291

104885

105793

109632

110985

5717

16

153

236

408

4904

112933

x62 WMD 09/11/26

P70

November 9, 2009 1:34:06 PM

Shop Packet Print

Page 4

W/O: 53595		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.12	230	Qty (60) AN960 JD10L REPLACED WITH Qty (60) AN960 C10L <i>perm change</i>	MD	09/11/26	60	<i>09.11.12</i>	<i>09.11.27</i>

Part No: D206-642-441 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

November 9, 2009 1:34:06 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			230	Each	4,361.000	1.0000			



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4361	
108161	503	
110523	340	
111279	101	
111916	482	
112314	2935	
16941	0	

X1 MD 09/11/26

CR3212-4-03



Purchased

No

230

Each

284.0000



2.0000

Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	284	
111359	88	
112314	196	

2 11/11/12



# Picklist Print

Page 6

November 9, 2009 1:34:06 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2651-1RevB		Manufactured	No			230	Each	327.0000	22.0000			
-------------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--



Plug

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

53349

ST

327

43990

57

45490

28

51530

242

X22 MD 09/11/26

D2651-3RevB		Manufactured	No			230	Each	959.0000	22.0000			
-------------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--



O-Ring

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

959

43849

3

46114

956

X22 MD 09/11/26

November 9, 2009 1:34:06 PM

Shop Packet Print

Page 6

# Picklist Print

Page 7

November 9, 2009 1:34:06 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-15RevB		Manufactured	No			230	Each	19.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	14	
51671	14	
Main Warehouse		
ST	5	
30750	4	
42233	1	

53462

XL MD 09/11/26

D3535-23RevB		Manufactured	No			230	Each	12.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51618	12	

53467

XL MD 09/11/26

November 9, 2009 1:34:07 PM

Shop Packet Print

Page 7

# Picklist Print

November 9, 2009 1:34:07 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-37RevB		Manufactured	No			230	Each	16.0000	1.0000			



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
51654	13	
Main Warehouse		
ST	3	
47374	3	

21 MO 09/11/20

D3536-15RevA Manufactured No



1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	29	
48159	3	
51600	26	

21 MO 09/11/20

# Picklist Print

Page 9

November 9, 2009 1:34:07 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3536-23RevA		Manufactured	No			230	Each	18.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Gasket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

FP

12

51609

12

Main Warehouse

ST

6

30754

1

47713

5

XT MD 09/11/26

D3536-37RevA		Manufactured	No			230	Each	18.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Gasket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

18

47375

5

51641

13

XT MD 09/11/26

# Picklist Print

November 9, 2009 1:34:07 PM

Work Order ID: 53595



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	282.0000	6.0000			



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	280	
51624	13	
51678	162	
51679	105	

X6 MD 09/11/20

D3537-3RevC

Manufactured No

230

Each

59.0000

1.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	59	
30758	7	
33881	17	
35697	35	

X1 MD 09/11/20

# Picklist Print

November 9, 2009 1:34:07 PM

Work Order ID: 53595

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube

Comments: IPP RevL: revise processe seq 09.11.03 DD verified by:EC

Start Date: 09/11/2009

Required Date: 20/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08		Purchased	No			230	Each	2,939.000	2.0000			
--------------	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--



Screw

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	2939	
110467	180	
110552	759	
110835	2000	

X2 MD 09/11/26

MS27039-4-06		Purchased	No			230	Each	71.0000	1.0000			
--------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Screw

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	71	
109061	71	

X1 MD 09/11/26

MS27039C1-08		Purchased	No			230	Each	962.0000	60.0000			
--------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



SCREW

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	962	
19185	962	

X60 MD 09/11/26

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2648	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

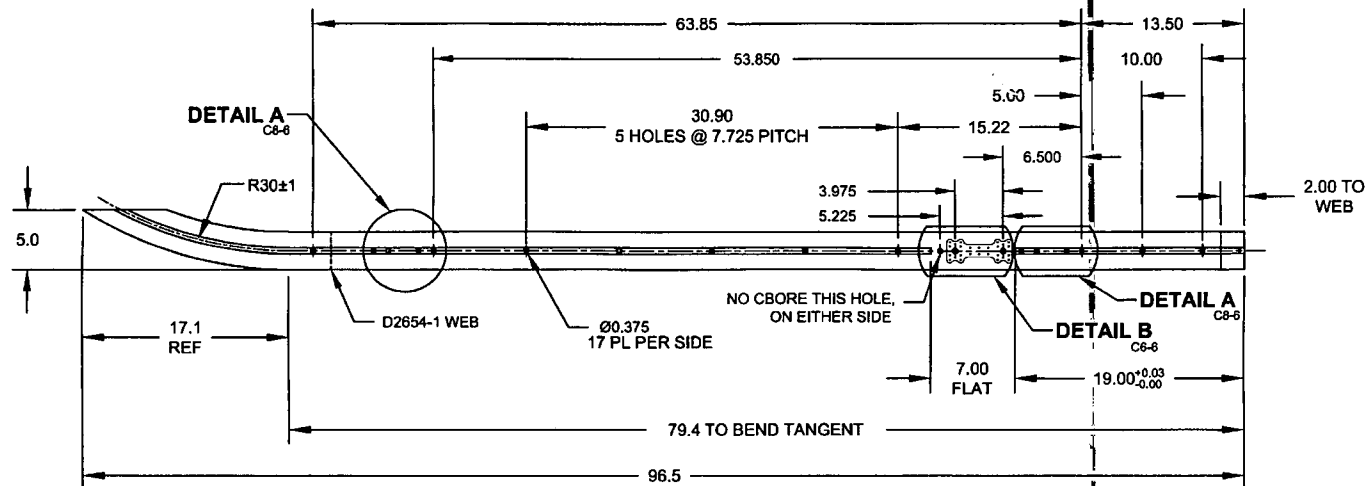
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK CENTER  
NO. 53595  
BP 09-11-9

RELEASED  
08.07.23

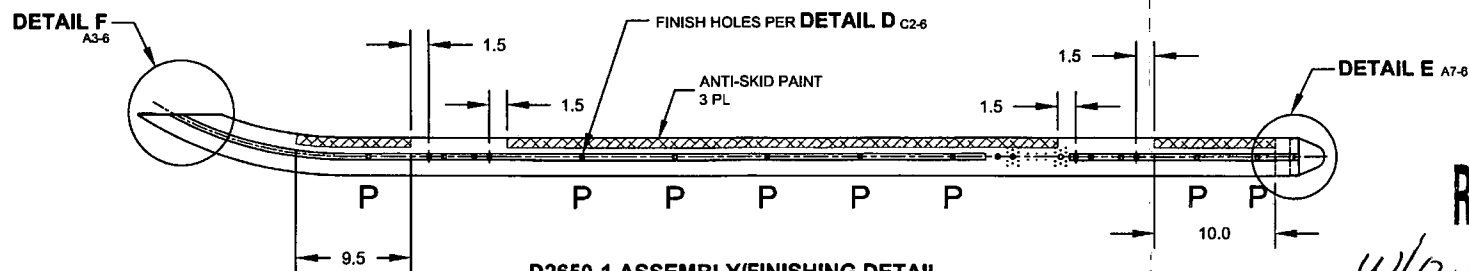
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**D2650-1 BENDING/DRILLING DETAIL**



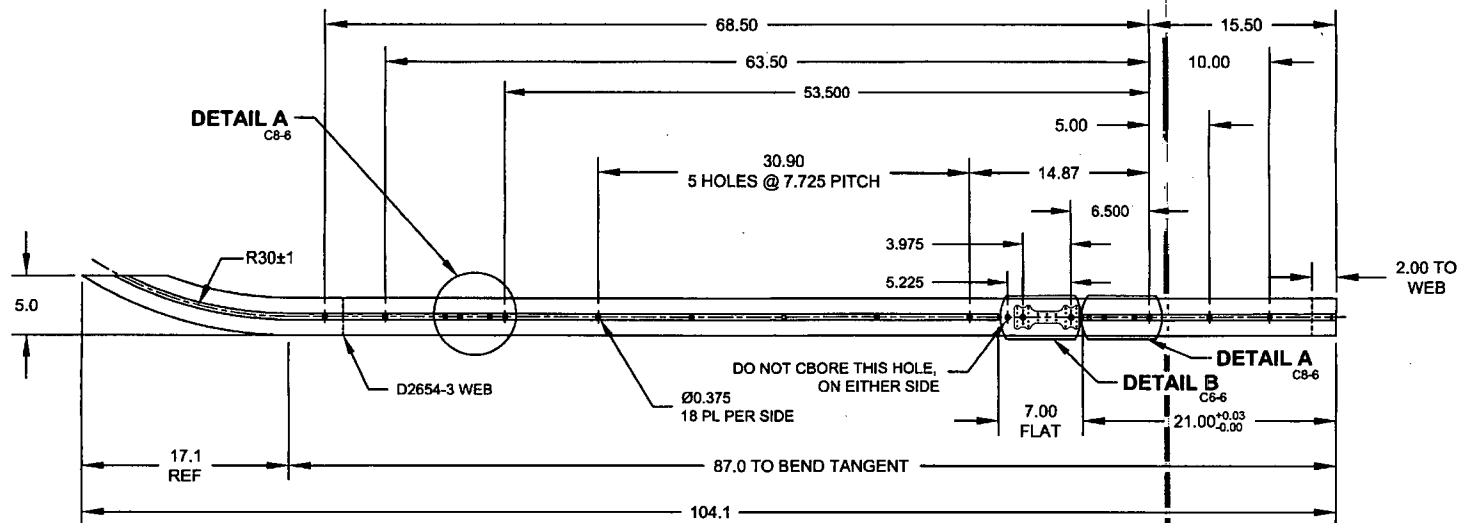
**D2650-1 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
680922/11P

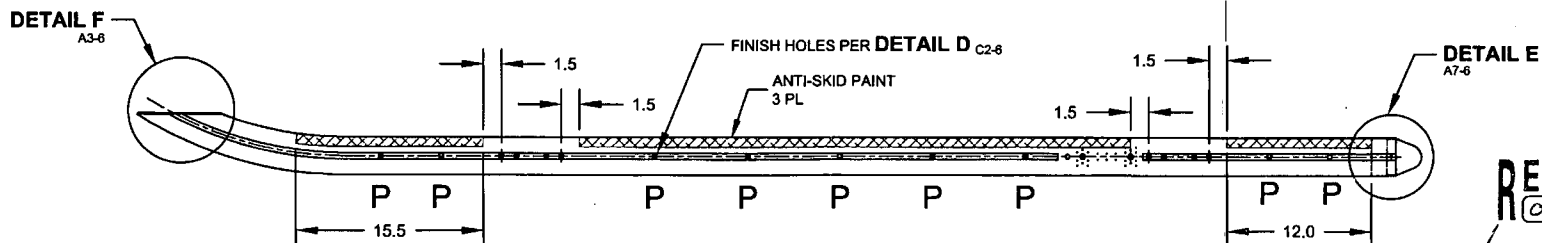
W/0 53595

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





**D2650-3 BENDING/DRILLING DETAIL**

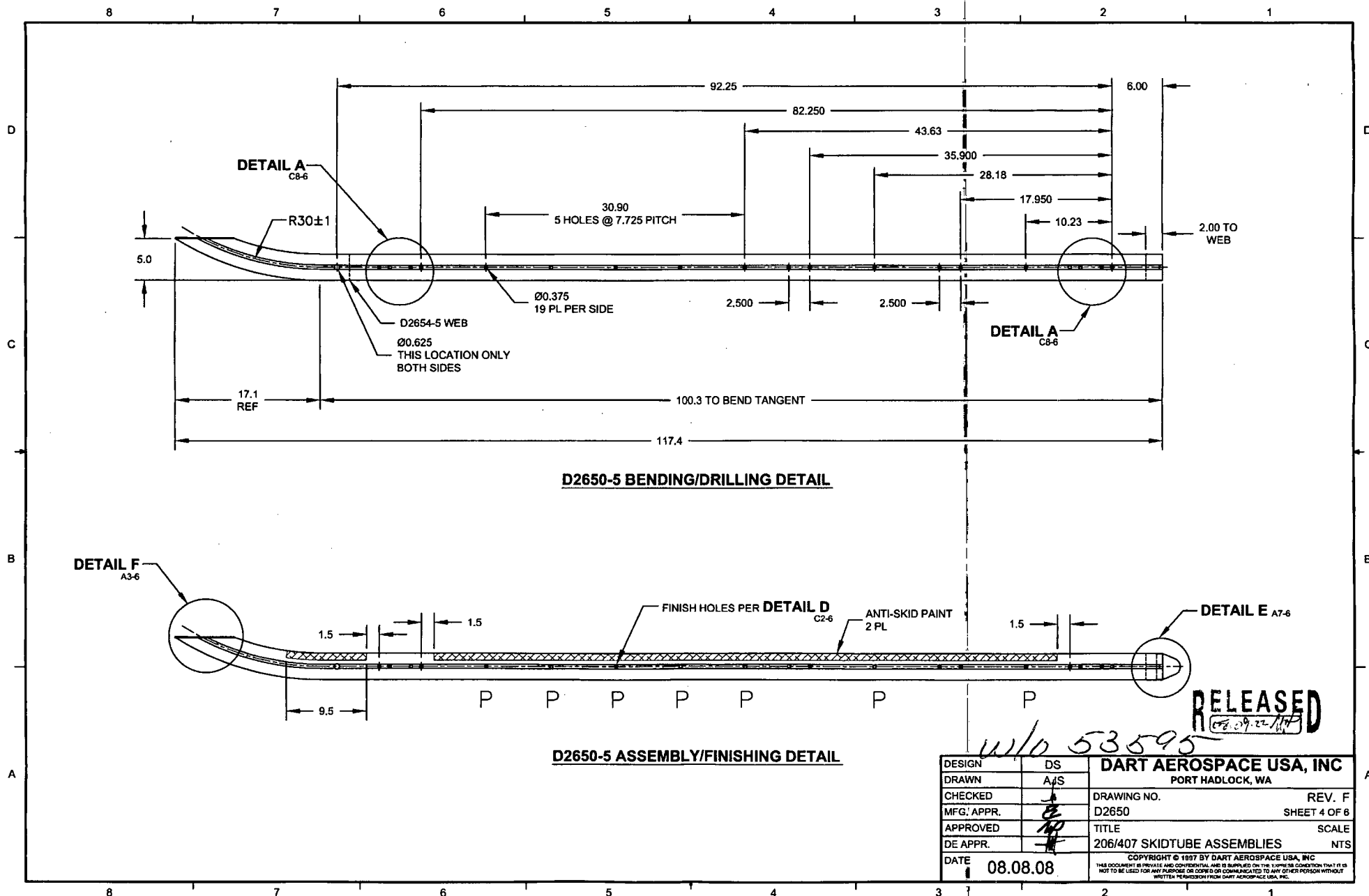


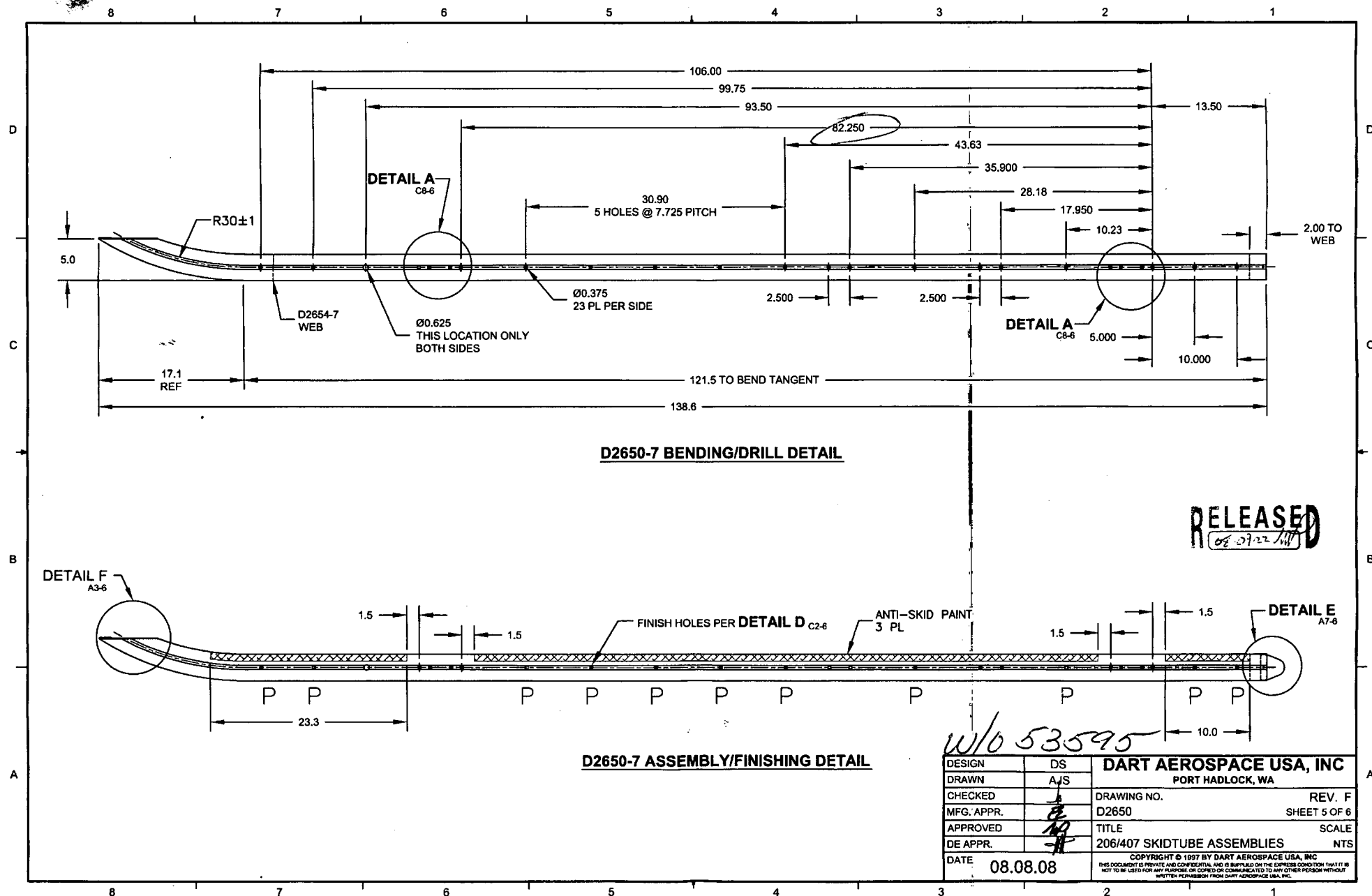
**D2650-3 ASSEMBLY/FINISHING DETAIL**

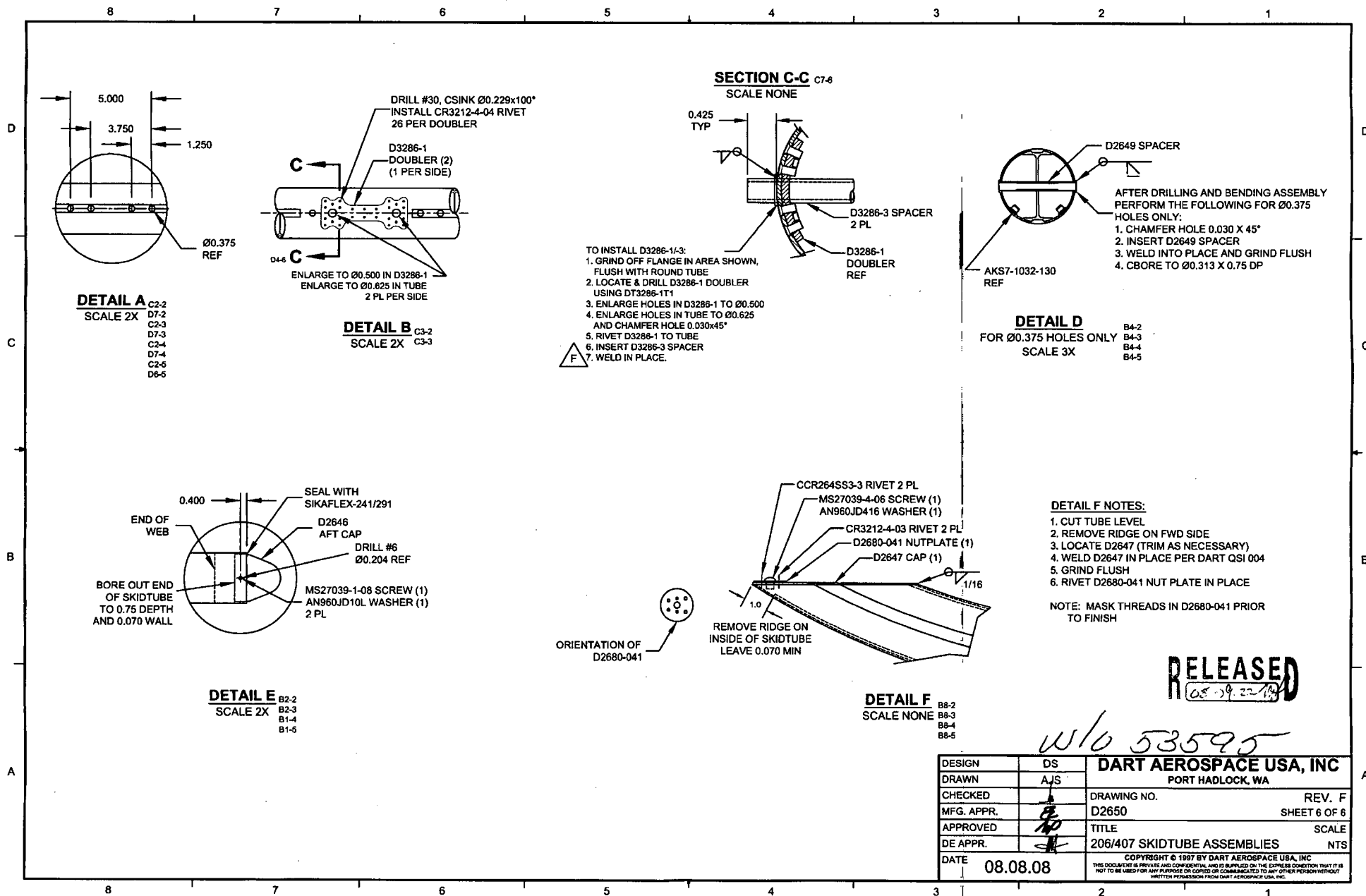
**RELEASED**  
06 07 02 100

W/6 53595

DESIGN	DS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D2650	SHEET 3 OF 6
APPROVED	J	TITLE	SCALE
DE APPR.	J	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	







NO. 216

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Berkeley Elliott  
Job number: D206 52867  
Part number: D206 642-541  
Description: ack skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Peterson Date of Test Coupon 09-11-10

Welder Berkeley Elliott Date of Test Coupon 09-11-10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld